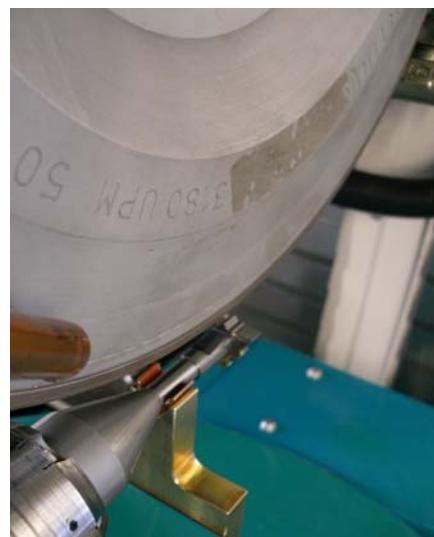
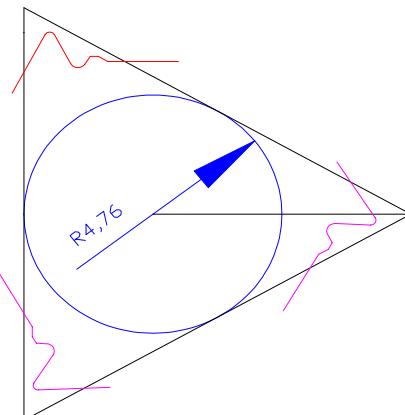


## Thread Insert ID 9.525

### A8-200-thread-m3

The Thread Insert are completely ground in one setup, including chipbreaker, using the Precision Pin Clamping system. A preliminary probing operations evaluates the orientation of the insert. The Profileoperations are based on VSW-Profilegrinding of our Quinto DXQ, where on most of the parts of the profile the flat sides of the V-Shaped wheel are touching the profile. It leads to a minimal wear of the large grinding wheels.



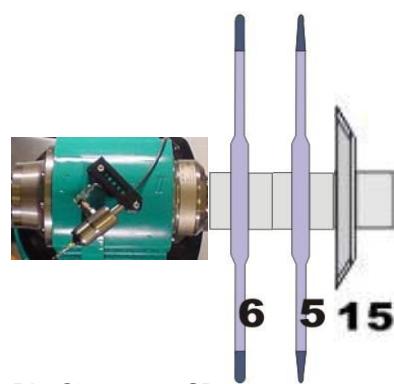
### 1. Cycletime for Production

Tool specifications				
Diameter 12 mm, Z 3, Length of cutting edge 5 mm				
Material HM				
Operations	Probe	Chipbrk.	Prof pregr	Prof fin.
Feed [mm/Min]	2000	120	120	170
Power [kW]		1	1	1
Cutting feed [m/s]		24	24	24
Used wheels		15	5	6
Grinding time [s]	19	60	75	60
Total cycle time	3 Min 34			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

15 Ø125 1V1 D64  
5 Ø300 14EE1 VSW D76  
6 Ø300 14EE1 VSW D46



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM, Precision Pin Clamping, S1L 650  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.2, DXQ

responsible engineer: OP,4.4.07

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

TECHNOLOGY  
FOR TOOLING